

Date: Tuesday, 22/07/2008 11:23:44 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
 Job Number : 40698
 Estimate Number : 10262
 P.O. Number :
 This Issue : 22/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SKIDTUBES
 Previous Run : 39972
 Written By :
 Checked & Approved By : JUD 08.7.22
 Comment :
 Est Rev: I 02.09.25 Rearranged procedure steps KJ
 Est Rev: J 06-03-23 As per Rev D JLM
 Est Rev: K 06-07.13 As per dsi9343 EC
 Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM
 Verified By: EC
 Est Rev: M 08-04-22 update steps 4, 13 DD verified by: EC

Part Number : D350636011
 Drawing Number : D2750 UNDER REVIEW *PH 08.07.22*
 Project Number : N/A *UPDATE PER DSI 9413*
 Drawing Revision :
 Material :
 Due Date : 10/08/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Sodolu



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG *004 + DSI 9413 PH 08.07.22*

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B32714

M 8-7-30 D

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B37768

①

M 8-7-30

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

M 8-7-29

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8330

5-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750 .Open up holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube***** Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297"

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M 108096/M 107877 BE 8-7-30*

10-Grind welds flush as per Dwg D2750

12- Scribe batch# inside per dwg D2750

5.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Job Number: 40698

Part Number: D350636011

Job Number:



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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

40723

① 48-7-30

10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

239584

REF 8-7-31

11.0	D34903	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

240727

REF 8-7-31

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

238755

REF 8-7-31

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on
sheet 4)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

M
8-7-30

W/O:		WORK ORDER CHANGES						
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Job Number: 40698

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

exp. date:

M107888

8-11-1

11-7-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

A/R Aluminum Rod

batch:

M108096

8-7-31

a.m 08.07.30

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

a.m 08.07.31

11-Deburr holes

a.m 08.07.31

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5

08/08/01

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5

08/08/01

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M108523

08/08/05

(X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50
320
1:20

M108523

08/08/05

(X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-08-06

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Job Number: 40698

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

ALS41032225

Insert



38 ~~18~~ 06.07.22



Comment: Qty.: 3 ~~42~~ 0000 Each(s)/Unit Total : 42 ~~3~~ 0000 Each(s)

Insert

Batch: M100489

HL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

HL

08.08.06

(X1)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B36230

HL

22.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B39715

HL

23.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B39716

HL

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B40552

HL

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B40553

HL

08.08.06

(X1)

W/O:		WORK ORDER CHANGES						
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Job Number: 40698

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 40729

JS

27.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 39422

JS

28.0

D35371

Wearpad



Comment: Qty.: ~~2~~ 0.0000 Each(s)/Unit Total : ~~2~~ 0.0000 Each(s)

WEARPAD

Batch: B 38941

JS

3 PA 08-07-22

29.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B 38139

JS

30.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B 38786

JS

31.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B 39725

JS

32.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B 40728

JS

08.08.06

(X1)

Dart Aerospace Ltd

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Job Number: 40698

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN3C5A

Bolt



34 ~~PA~~ 08.07.22



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M108302

PA

34.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M105300

PA

35.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch:

DSJ 9413

PA 08.07.22

NOT REQ'D

36.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M108284

PA

37.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M106896

PA

38.0

AN960C10L

washer



38 ~~PA~~ 08.07.22



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

washer

Batch: M108672

PA

39.0

AN960C816L

WASHER



PA 08.07.22



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

WASHER

Batch: M107520

PA

08.08.06

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 40698

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M108744

HL

41.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M1108744

HL

42.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M1107394

HL

43.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch:

NOT REQ'D
PER DSI 9413 18 07.07.22

44.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

B39694

HL

45.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

M108062

HL

46.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

M108079

HL

08.08.06

K1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 40698

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Phenolic Washer B39275 22

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: M10792

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

✓ SIKA FLEX 241

BATCH: M108801

EXP DATE: 08/10

✓ 4-Coat all exposed fasteners with "LPS Procyon" batch: M104251 22 08-08-06 (41)

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/11 (40)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



CHG 004 Pt 08.07.22

Comment: PACKAGING RESOURCE #1

Pick Packing Kit

51.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Blade
Batch: B38538

52.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Batch: M107924 8/8/11

54

(41)

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 40698

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107520

SC

54.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M107581

SC

55.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M108744

SC

56.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M39985

SC

57.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: M538594

8/8/11

SC

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/08/11 (40)

59.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Rev G 8/8/08/11

CHG 004 Pdt 08.07.22

W/O:		WORK ORDER CHANGES						
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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

60.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

A 000010

MF 08-08-10

Job Completion



B40698

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART**RELEASED**
07.08.02

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D2750	REV. E SHEET 1 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

PH 08.07.22
UNDER REVIEW
08.06.27
UPDATE
PER
NSI 9419

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	

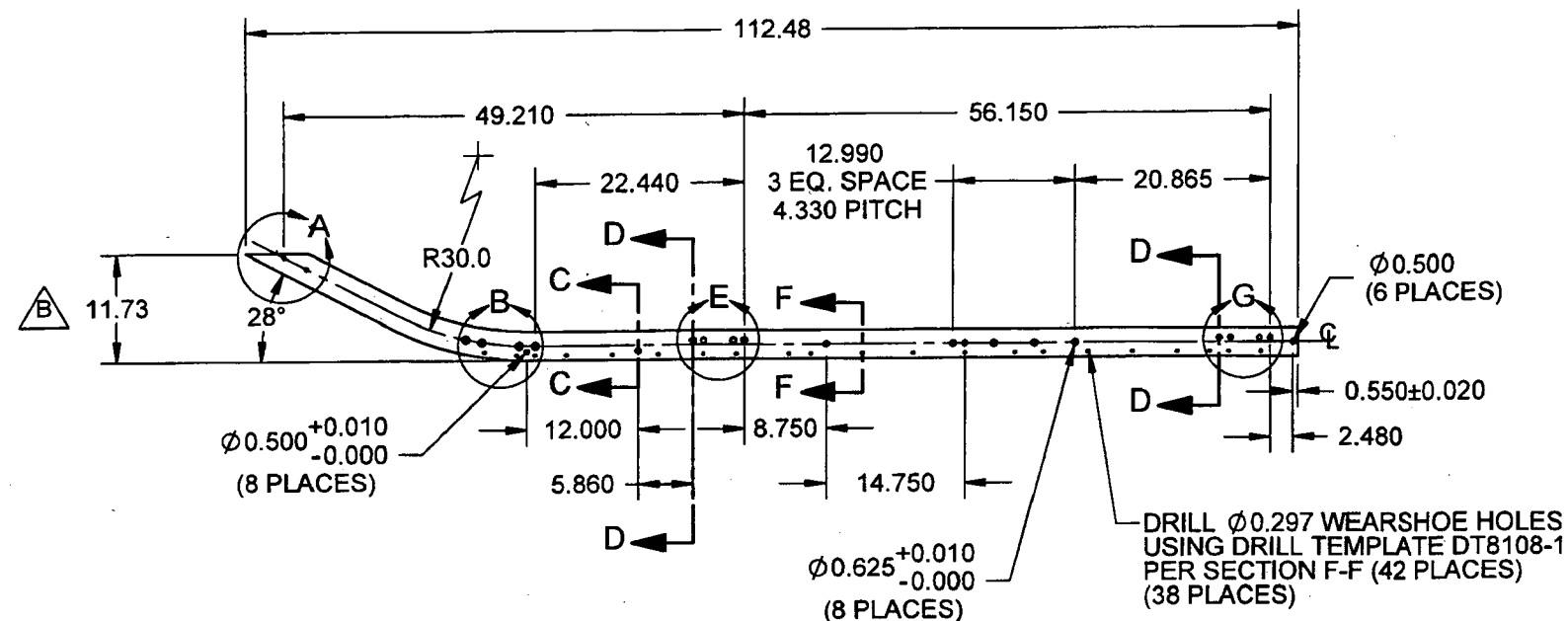
GENERAL NOTES:**RELEASED**
07.08.02 *[Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/4. WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

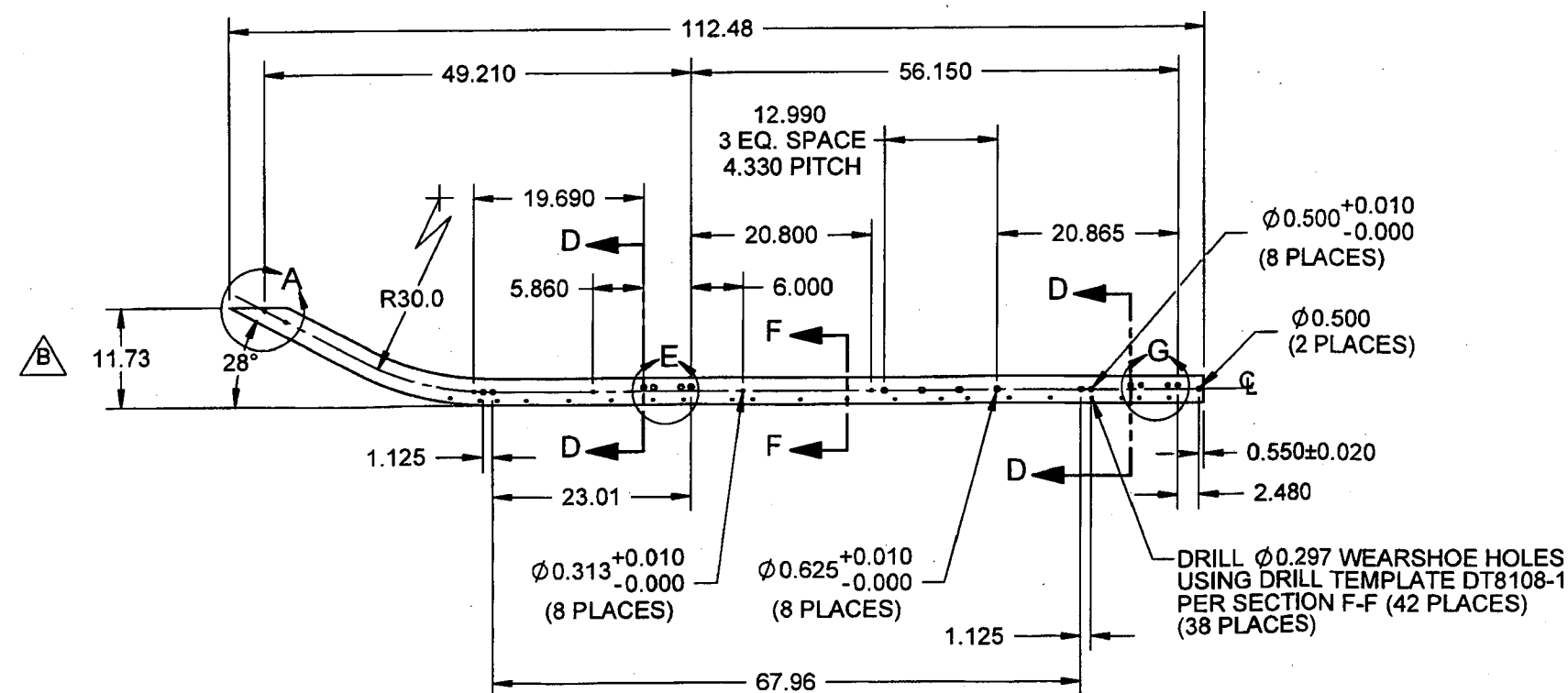
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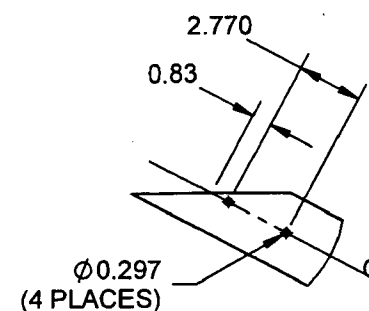
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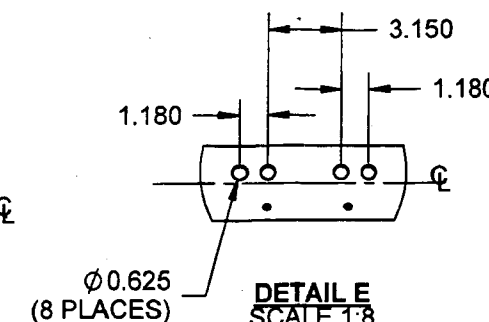
D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



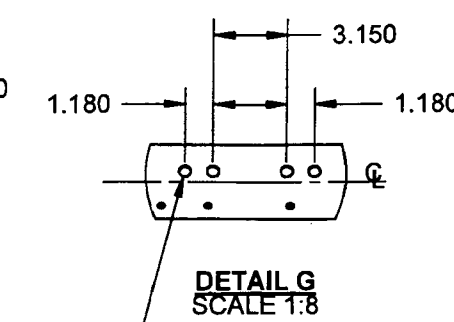
D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



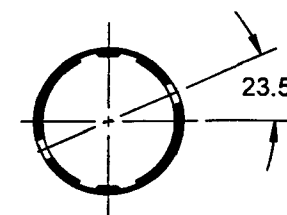
DETAIL A
SCALE 1:8



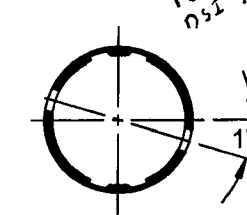
DETAIL E
SCALE 1:8



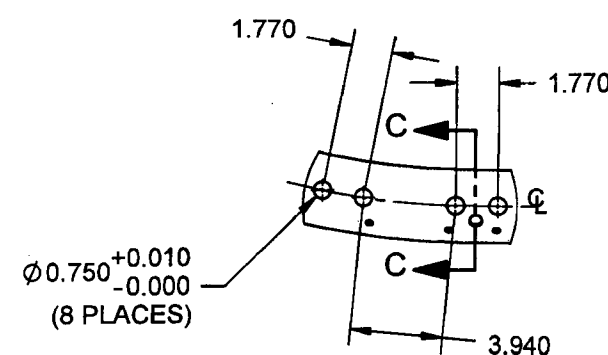
DETAIL G
SCALE 1:8



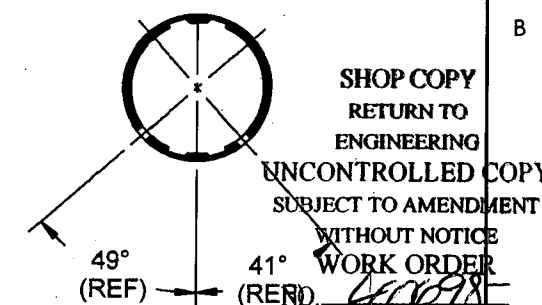
SECTION C-C
SCALE 1:4



SECTION D-D
SCALE 1:4



DETAIL B
SCALE 1:8
(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)



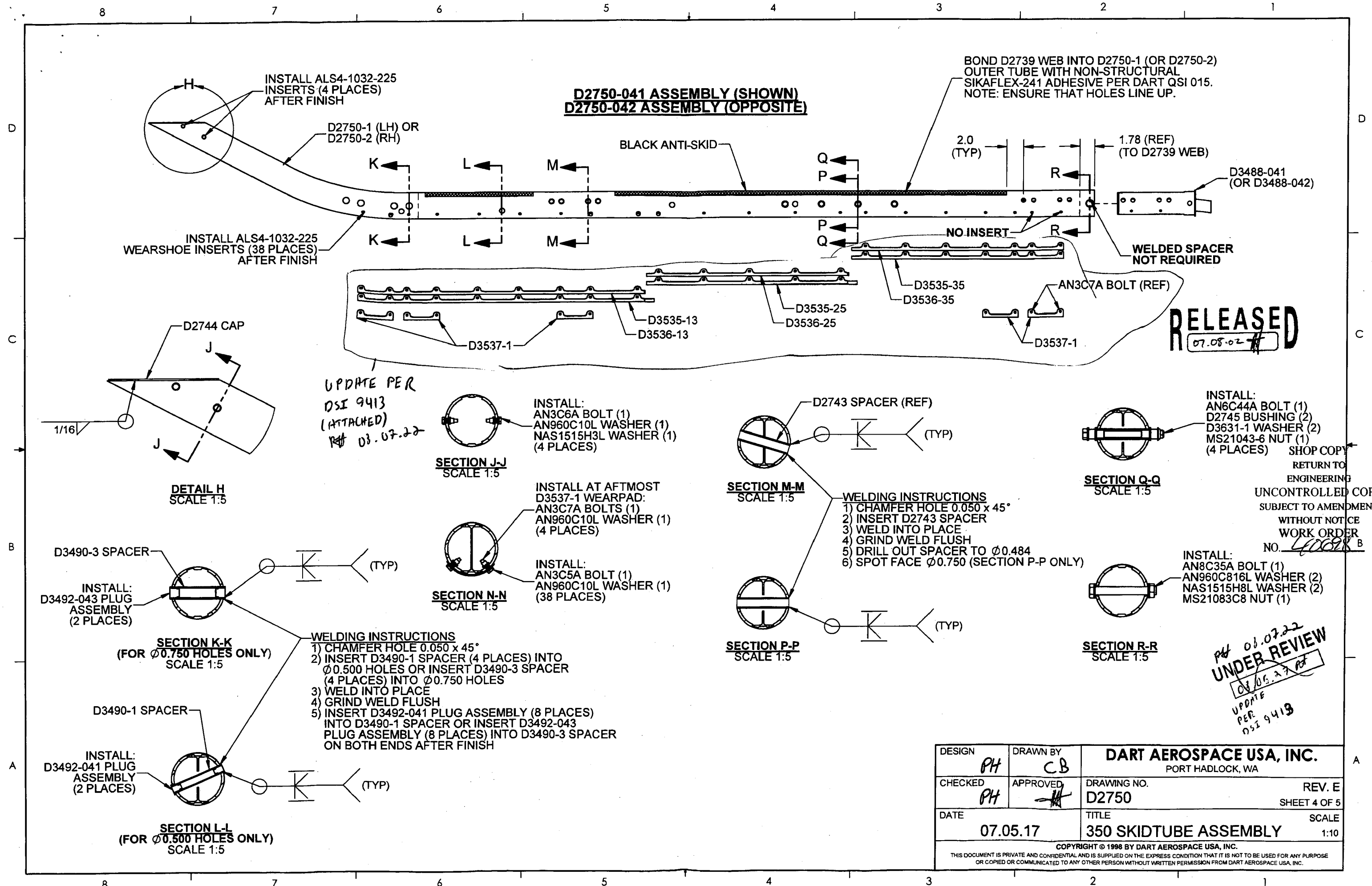
SECTION F-F
SCALE 1:4

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DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20	

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INSTALL ALS4-1032-225
INSERTS (4 PLACES)
AFTER FINISH

D2750-1 (LH) OR
D2750-2 (RH)

INSTALL ALS4-1032-225
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

**D2750-041 ASSEMBLY (SHOWN)
D2750-042 ASSEMBLY (OPPOSITE)**

BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

RELEASED
07.05.02

UPDATE PER
DSI 9413
(ATTACHED)
03.07.22

INSTALL:
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

**SECTION J-J
SCALE 1:5**

INSTALL AT AFTMOST
D3537-1 WEARPAD:
AN3C7A BOLTS (1)
AN960C10L WASHER (1)
(4 PLACES)

INSTALL:
AN3C5A BOLT (1)
AN960C10L WASHER (1)
(38 PLACES)

**SECTION N-N
SCALE 1:5**

D2743 SPACER (REF)

**SECTION M-M
SCALE 1:5**

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D2743 SPACER
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) DRILL OUT SPACER TO Ø0.484
6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

INSTALL:
AN6C44A BOLT (1)
D2745 BUSHING (2)
D3631-1 WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)

**SECTION Q-Q
SCALE 1:5**

INSTALL:
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

**SECTION R-R
SCALE 1:5**

D3490-3 SPACER

INSTALL:
D3492-043 PLUG
ASSEMBLY
(2 PLACES)

**SECTION K-K
(FOR Ø0.750 HOLES ONLY)
SCALE 1:5**

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D3490-1 SPACER (4 PLACES) INTO
Ø0.500 HOLES OR INSERT D3490-3 SPACER
(4 PLACES) INTO Ø0.750 HOLES
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES)
INTO D3490-1 SPACER OR INSERT D3492-043
PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER
ON BOTH ENDS AFTER FINISH

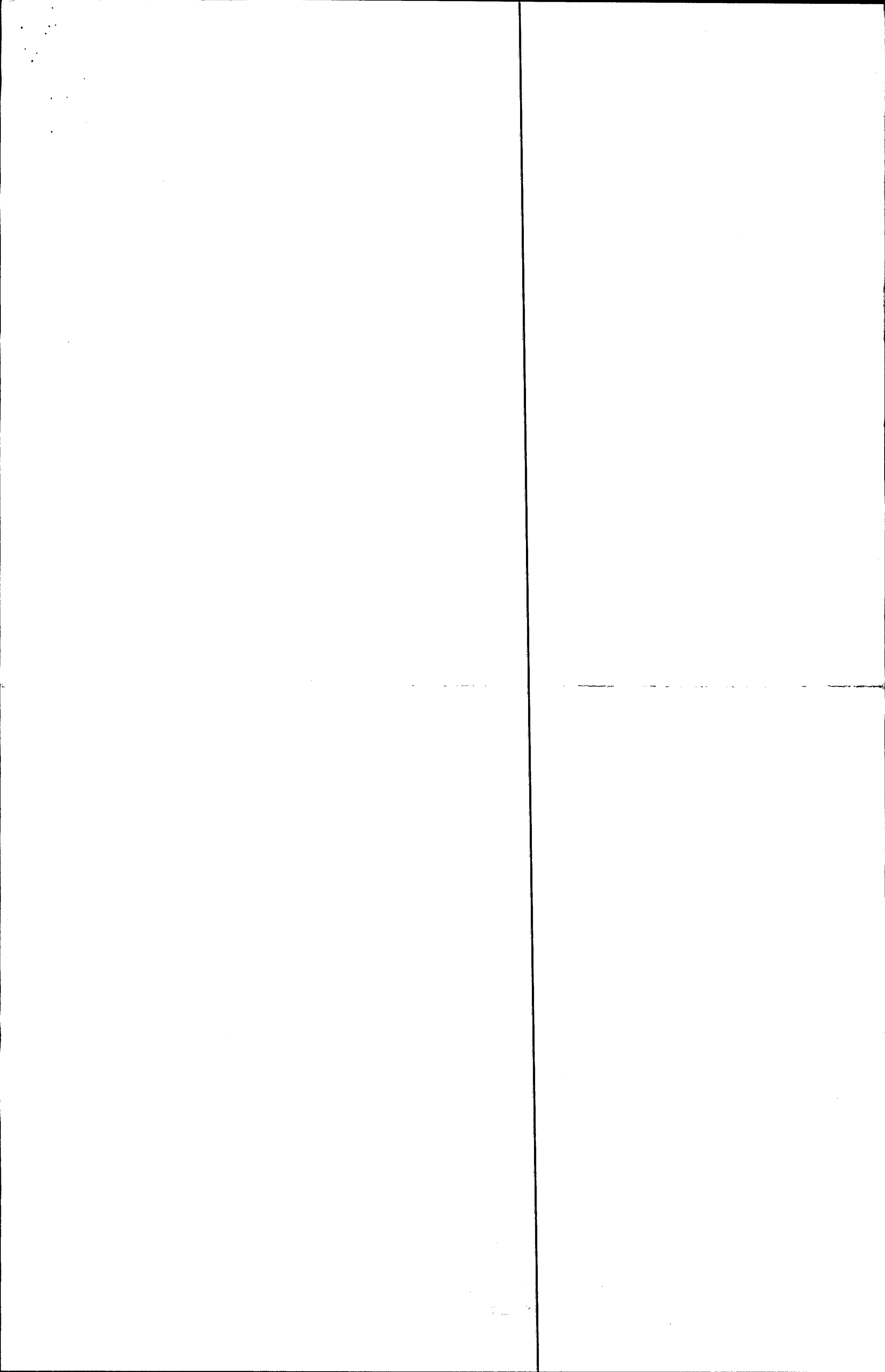
D3490-1 SPACER

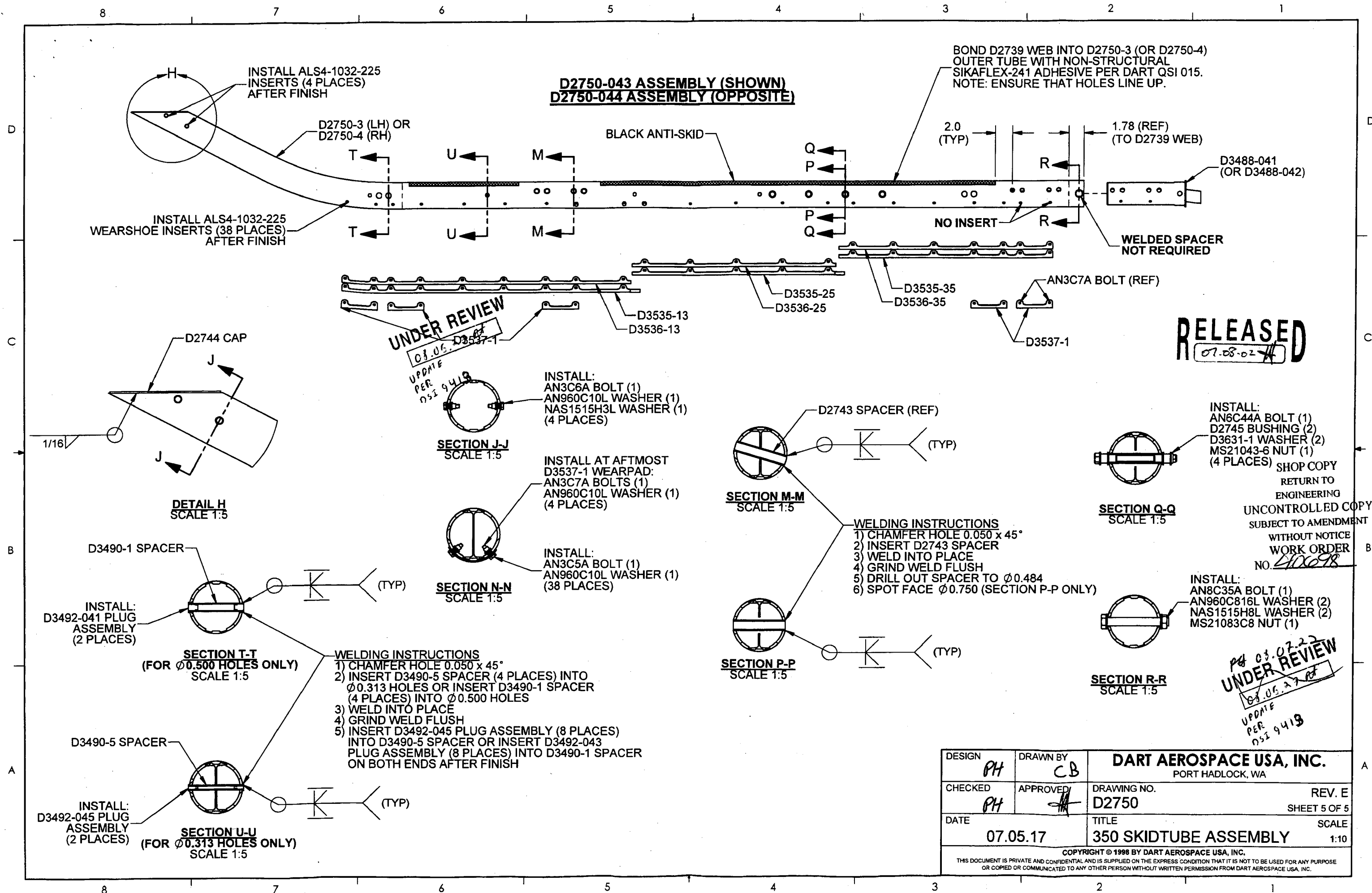
INSTALL:
D3492-041 PLUG
ASSEMBLY
(2 PLACES)

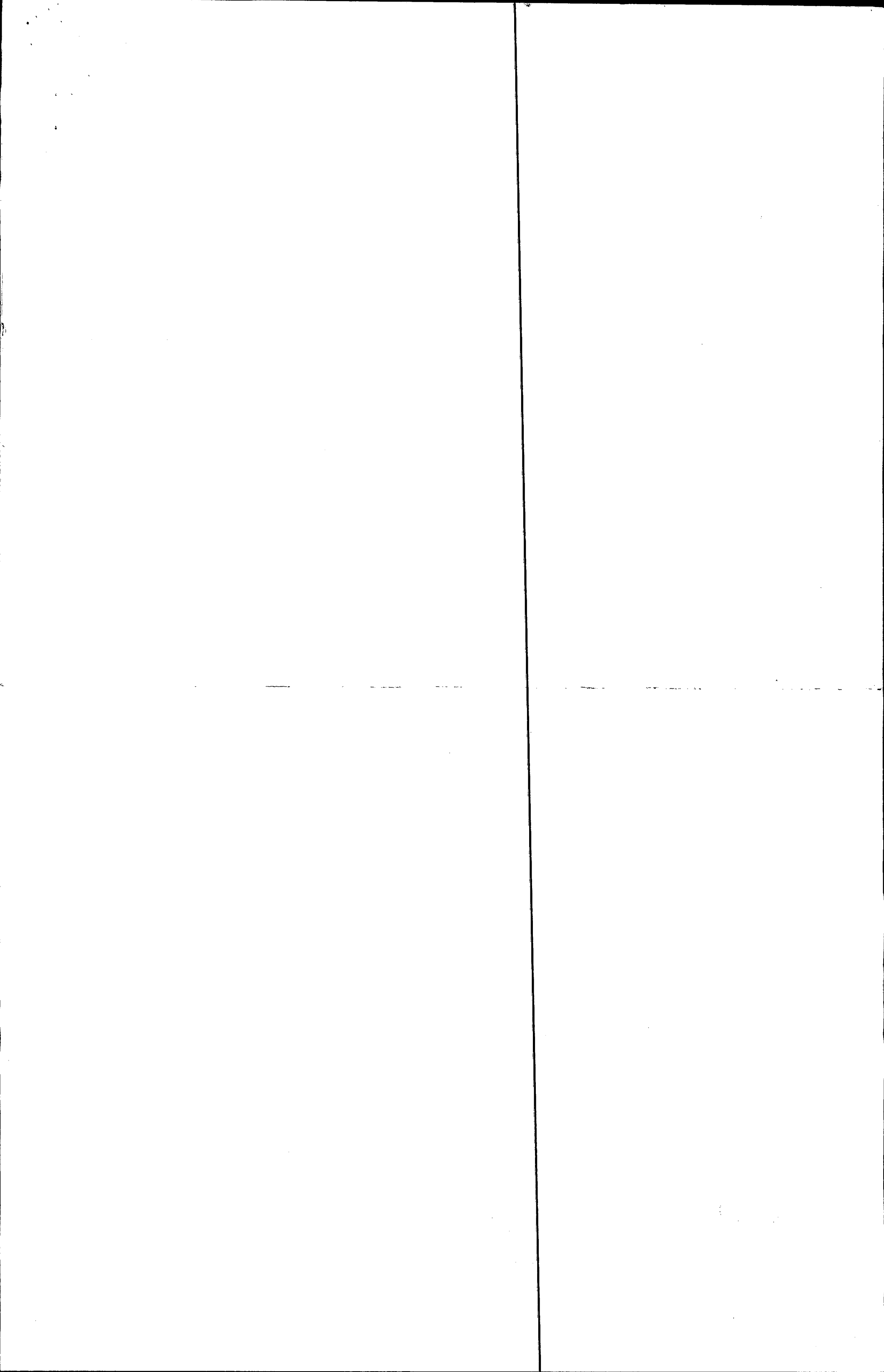
**SECTION L-L
(FOR Ø0.500 HOLES ONLY)
SCALE 1:5**

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07.05.22
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PER
DSI 9413

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DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10	
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DART SERVICE INSTRUCTION

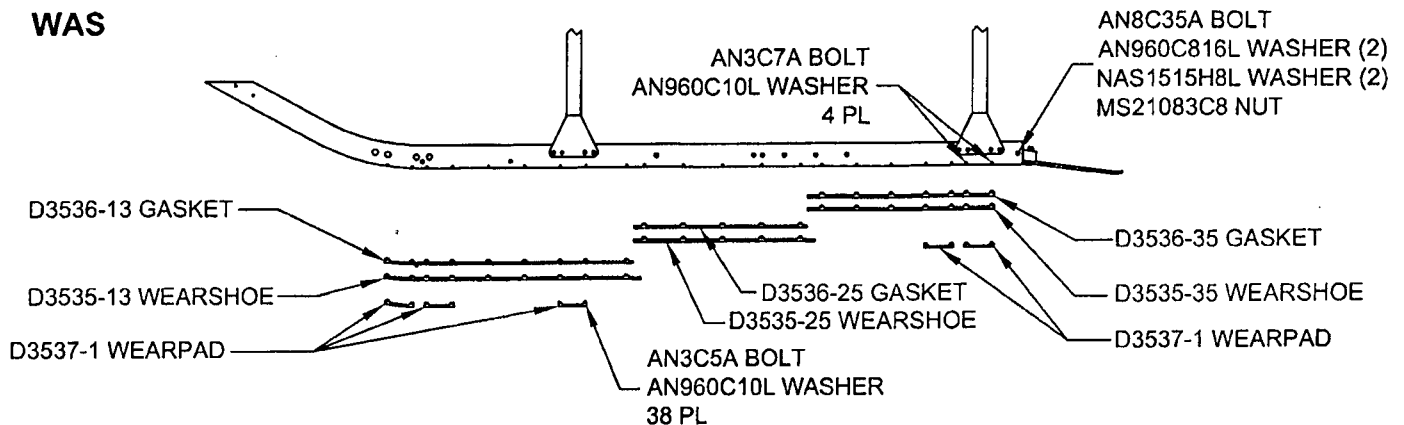
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

WAS



NOW

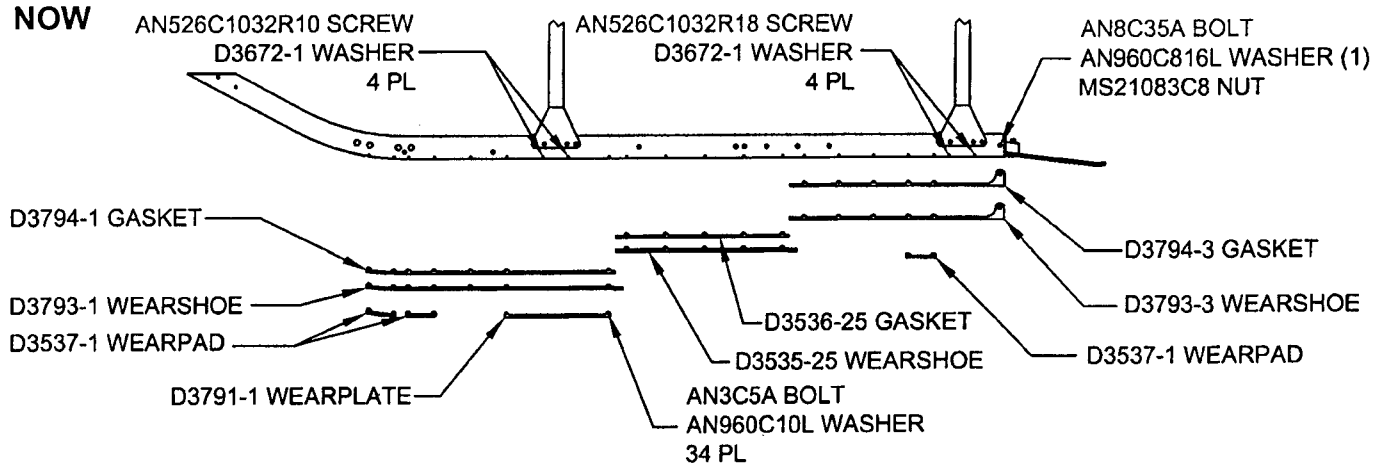


FIGURE 1 - WEARPLATE MODIFICATION

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

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A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
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MFG. APPR.	N/A	DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE MODIFICATION	NTS
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FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

Item	Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
*6A	1	1	1	1	AN960C816L	WASHER
6B	2	2	2	2	NAS1515H8L	WASHER
*22	2	2	2	2	D3537-1	WEARPAD
23A	1	1	1	1	D3535-13	WEARSHOE
23B	1	1	1	1	D3536-13	GASKET
25A	1	1	1	1	D3535-35	WEARSHOE
25B	1	1	1	1	D3536-35	GASKET
*26A	4	4	4	4	AN3C5A	BOLT
*26B	4	4	4	4	AN3C7A	BOLT
*27	8	8	8	8	AN960C10L	WASHER

*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
			X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
8	8	8	8	D3672-1	WASHER
4	4	4	4	AN526C1032R10	SCREW
4	4	4	4	AN526C1032R18	SCREW

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TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

Qty -011	Part Number	Description
X	DSI 9413-011	WEARSHOE MODIFICATION KIT
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
8	D3672-1	WASHER
4	AN526C1032R10	SCREW
4	AN526C1032R18	SCREW

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. NOTE: SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

Qty -011	Part Number	Description
X	D350-636-045	WEARSHOE KIT
3	D3537-1	WEARPAD
1	D3535-25	WEARSHOE
1	D3536-25	GASKET
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
34	AN3C5A	BOLT
34	AN960C10L	WASHER

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NO. 159

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 399164
Part number: D350 636012
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dugli Date of Test Coupon 08-06-23

Welder Barclay Elliot Date of Test Coupon 08-06-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

33

Date: Tuesday, 22/07/2008 2:00:32 PM
User: Julie Leed

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 40698
Estimate Number : 10262
P.O. Number :
This Issue : 22/07/2008 S.O. No. :
Prsht Rev. : NC Part Number : D350636011
First Issue : 22/07/2008 Type : SKIDTUBES Drawing Number : D2750 UNDER REVIEW
Previous Run : 39972 Drawing Revision :
Material :
Due Date : 10/08/2008 Qty: 1 Um: Each

Written By :
Checked & Approved By :
Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ
Est Rev:J 06-03-23 As per Rev D JLM
Est Rev:K 06-07-13 As per dsi9343 EC
Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM
Verified By:EC
Est Rev:M 08-04-22 update steps 4, 13 DD verified by:EC

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08/8/7



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 003

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: _____

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.